

Work Order ID 72142

Tuesday, July 19, 2011 1:44:22 PM



Page 1

Item ID: D3917-3

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 7/19/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 7-19-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3917

A

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA876 & DWG

FOLIO REV: 4/16

DWG REV: A

DEBURR

SL 10819

22 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10819

22 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

20 11-8-9

22

130

Identify as per dwg & Stock Location: 92

0.00



Packaging

Memo

0.00

Packaging

11/8/10 SP (22)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/10

11-08-10
(22)

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Picklist Print

Tuesday, July 19, 2011 1:44:28 PM

Page 1

Work Order ID: 72142

Parent Item: D3917-3

Parent Item Name: Washer



Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 09-12-02 JLM Verified by:DD
per dwg REV.A DD 10.02.22 verified by:EC
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELNRINR0.750		Purchased	No			100	f	42.7980	0.02	0.421053			
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Delrin Round Bar 0.75"



Handwritten: 11/8/9

Location

Loc Qty

Loc Code

MAT055

42.798

115472

7.5

116183

2.4

117273

9.958

117322

0.94

118066

22

Handwritten: 0.3 ft

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

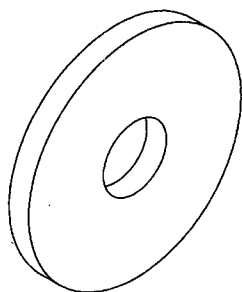
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

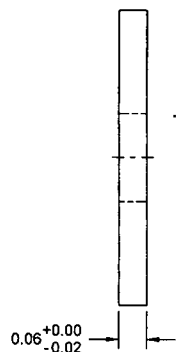
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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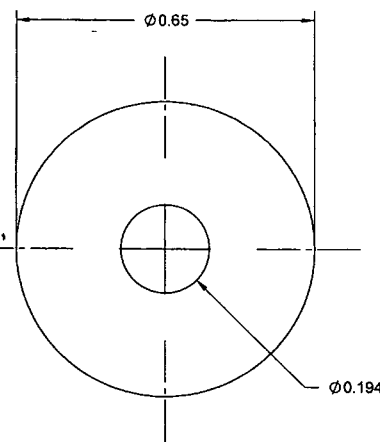
NOTE: Date & initial all entries



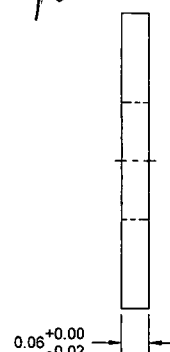
ISO VIEW



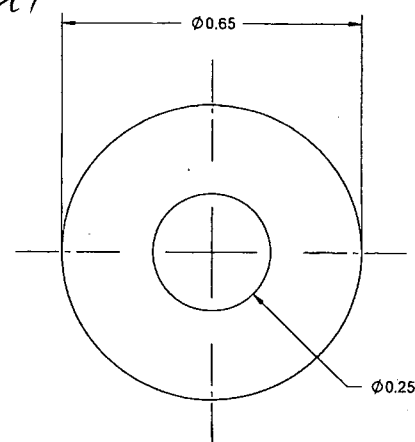
0.06^{+0.00}
-0.02



D3917-1 WASHER



0.06^{+0.00}
-0.02



D3917-3 WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *72172*
11-0219

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, COLOR BLACK
REF DART SPEC M-DELRIN-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: < 0.01 lbs

RELEASED
2010-02-16
MP

REV.	NEW ISSUE	DESCRIPTION	JPH	10.01.29
DESIGN	AJS		BY	DATE
DRAWN	AJS			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>			
DATE	10.01.29			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3917** REV. A
SHEET 1 OF 1
TITLE **WASHER (350 BASKET)** SCALE NTS

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